

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Page 2

Accept

**Setup Start**

[REDACTED]

Stop

[illegible]

Cust Item ID:



Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Date: _____

**Insp.
Stamp**

0.00



0.00 8.00/2/1

QC

Memo

0.00

Quality Control

Identify as per dwg & Stock Location: 22

0.00



Memo

0.00

Packaging

Packaging

QC21- Final Inspection - Work Order Release

0.00

[illegible]

Memo

0.00

QC

Quality Control

420

10/8/10 100 \$

10/08/10 AJ

MF:
10-8-10

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NOTE: Date & initial all entries

Picklist Print

August 4, 2010 8:55:13 AM

Page 1

Work Order ID: 61006



Parent Item: D4148-1



Parent Item Name: Crosstube Lug Plate, Fwd

Start Date: 8/04/10

Required Date: 8/11/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA		Purchased	No			100	sf	91.2982	0.3607	3.796842			
-----------	--	-----------	----	--	--	-----	----	---------	--------	----------	--	--	--



304/316 0.125 Sheet



B 10-8-9

Location

Loc Qty

Loc Code

MAT	91.2982	
114488	1.5259	
114799	89.7723	

114799

18

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 61001
Description: CROSSTUBE Lug PLATE FWD		Part Number: 4148-1
Inspection Dwg: D4148-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

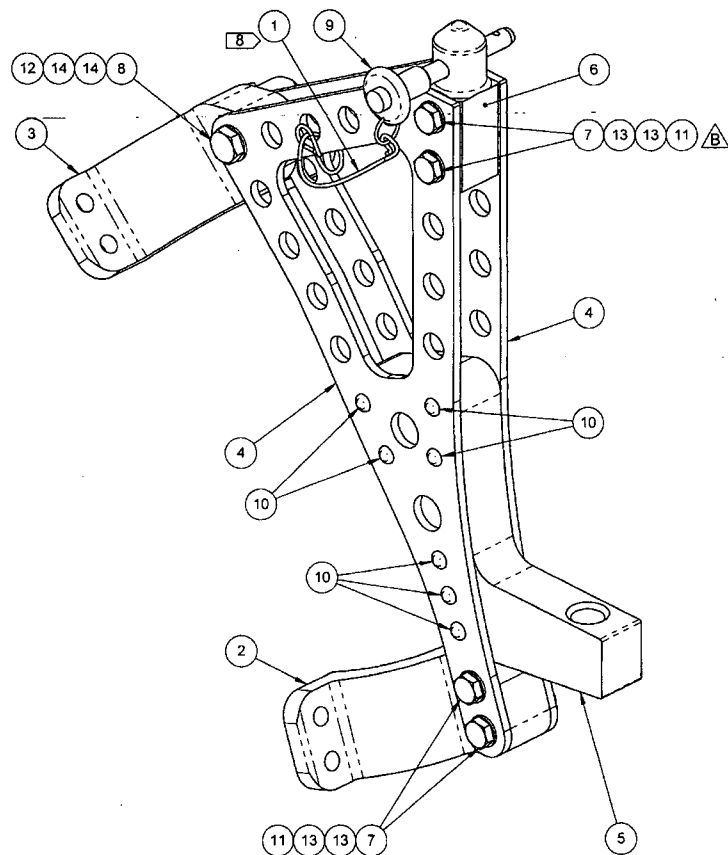
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .139	+ .005 - .001	.131			V HB02	
Ø .257	+ .006 - .001	.254			V	
Ø .191	+ .005 - .001	.193			V	
Ø .138	+ .006 - .001	.139			V	
2.47	TL .030	2.463			V	
.82	TL .030	.821			V	
3.57	TL .030	3.573			V	
1.23	TL .030	1.232			V	
.90	TL .030	.902			V	
.310 3.10	TL .010	.313			V	
.750	TL .010	.752			V	
1.98	TL .030	1.981			V	
1.84	TL .030	1.836			V	
.92	TL .030	.917			V	
.375	TL .010	.377			V	
4.730	TL .010	4.732			V	
5.30	TL .030	5.301			V	
1.10	TL .030	1.107			V	
2.284	TL .010	2.283			V	
.625	TL .010	.629			V	
1.000	TL .010	1.002			V	
.500	TL .010	.561			V	
.750	TL .010	.754			V	

Measured by: RB
Date: 10-8-9

Audited by: S
Date: 10/08/09

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4148-041 FWD X-TUBE LUG ASSY


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.47 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	4	AN3C12A	
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	7	MS20615-4M18	RIVET
11	4	MS21043-3	NUT
12	1	MS21043-4	NUT
13	8	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61004
DP10-8-4

RELEASED
2010-07-16
mb

B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3, AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.1912 PL REPLACES Ø0.1293 PL (ZN D6-3); Ø0.1297 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4148 REV. B SHEET 1 OF 5 TITLE FWD X-TUBE LUG ASSY SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE			

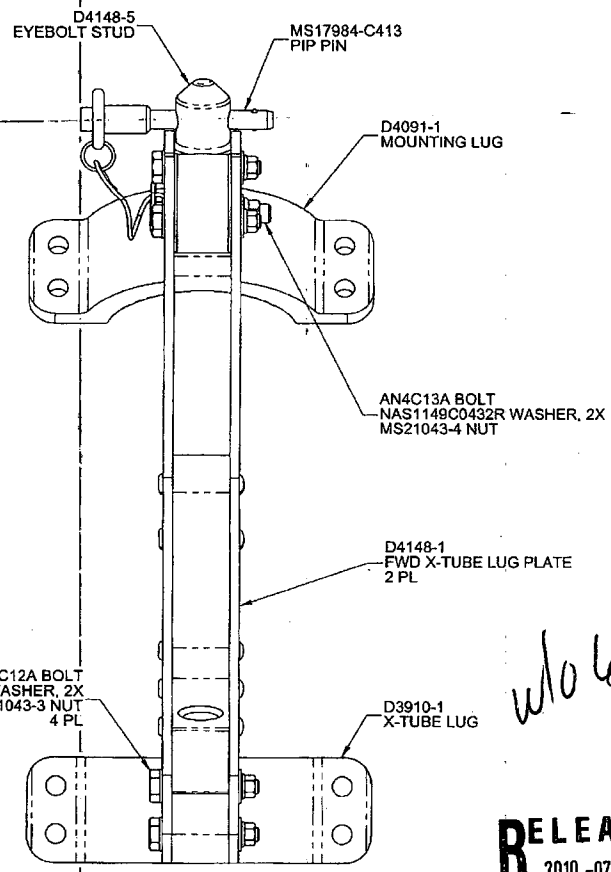
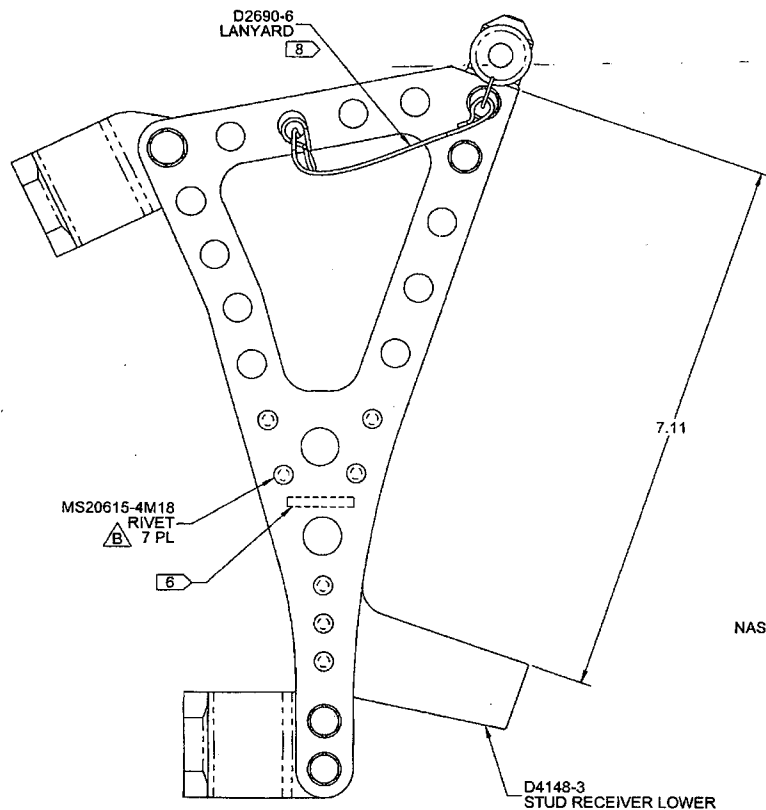
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



who hook

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2010-07-16

D4148-041 FWD X-TUBE LUG ASSY

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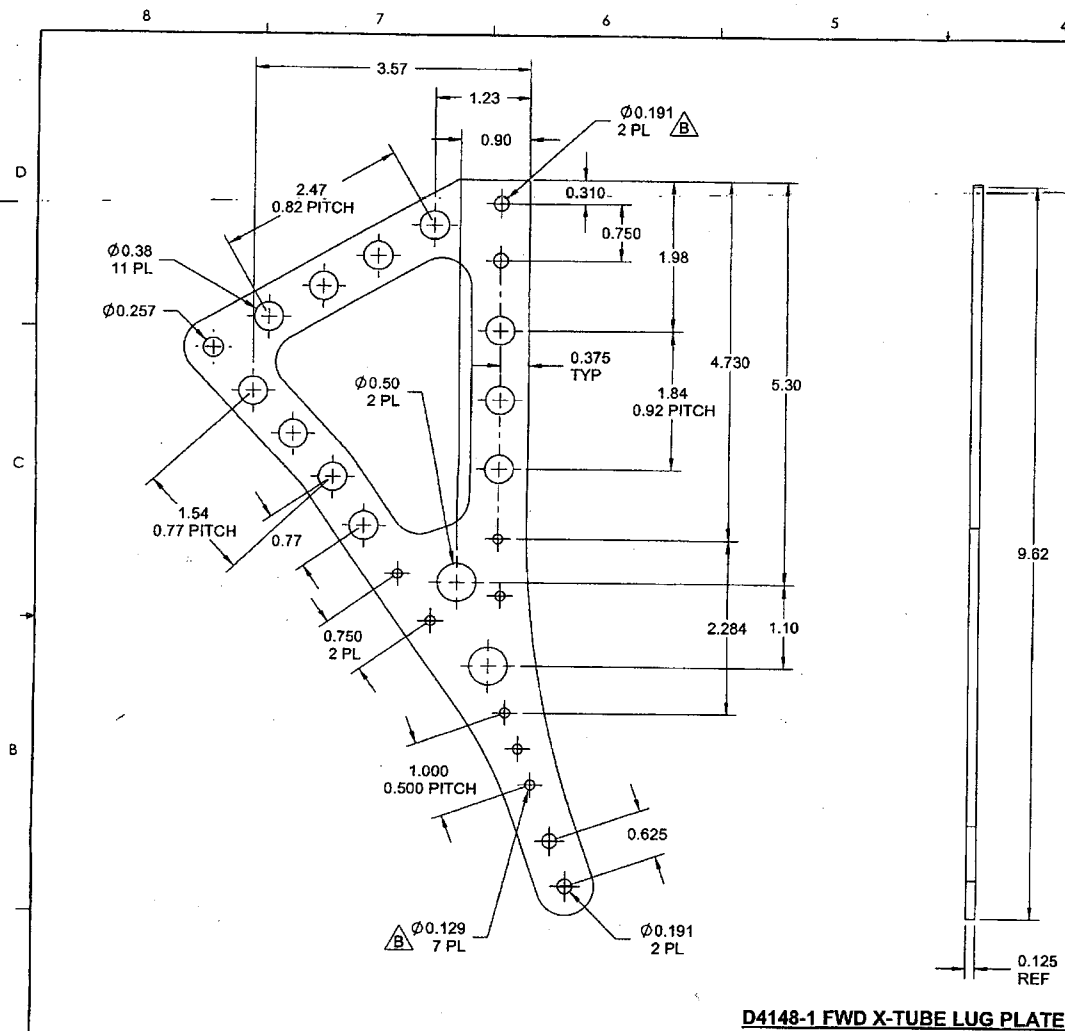
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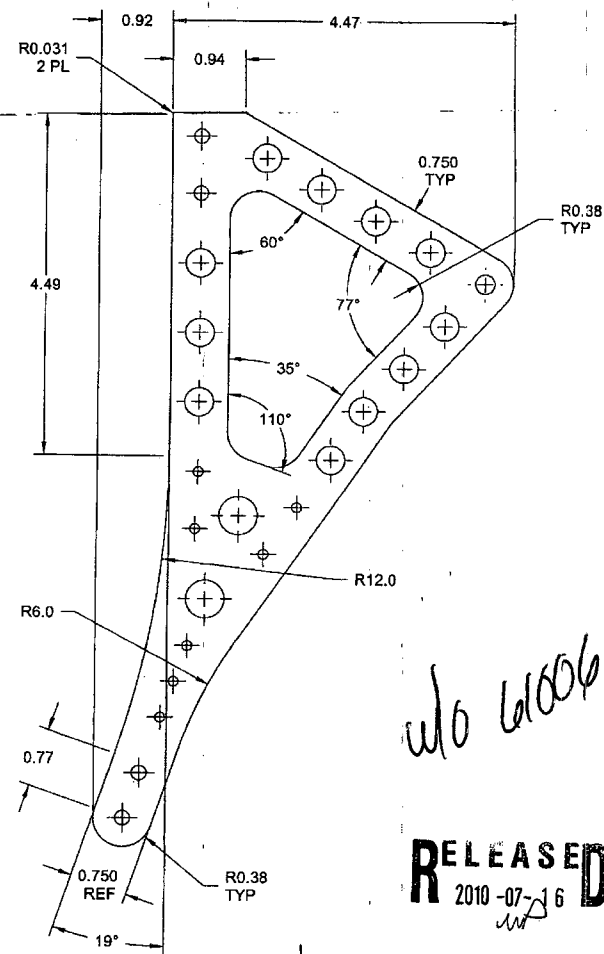
NOTE: Date & initial all entries



D4148-1 FWD X-TUBE LUG PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC MS304S11GA OR MS303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.48 lbs



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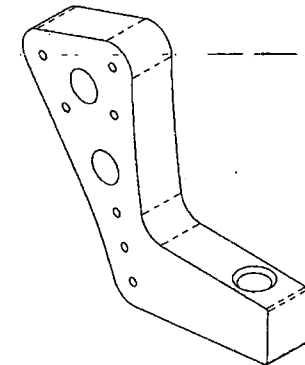
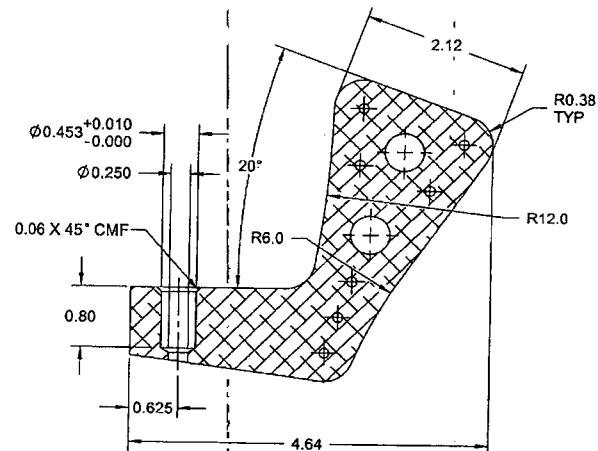
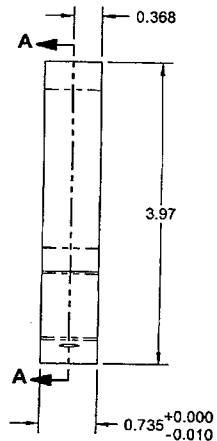
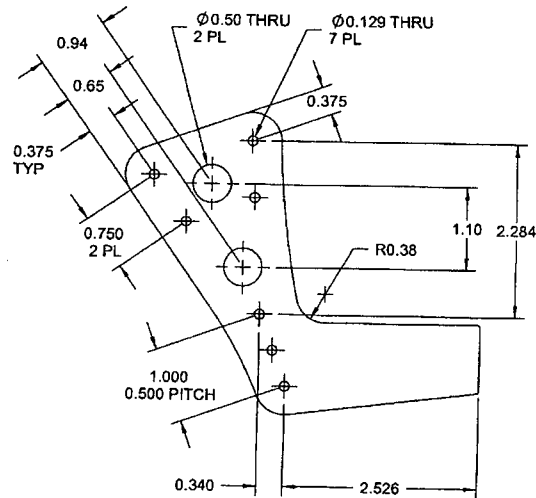
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NOTE: Date & initial all entries



D4148-3 STUD RECEIVER LOWER

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.44 lbs

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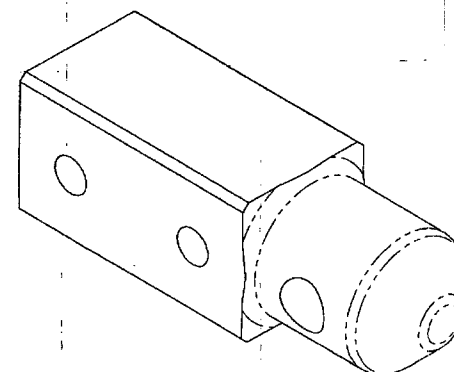
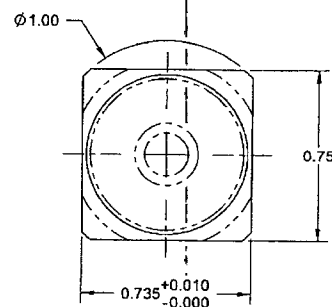
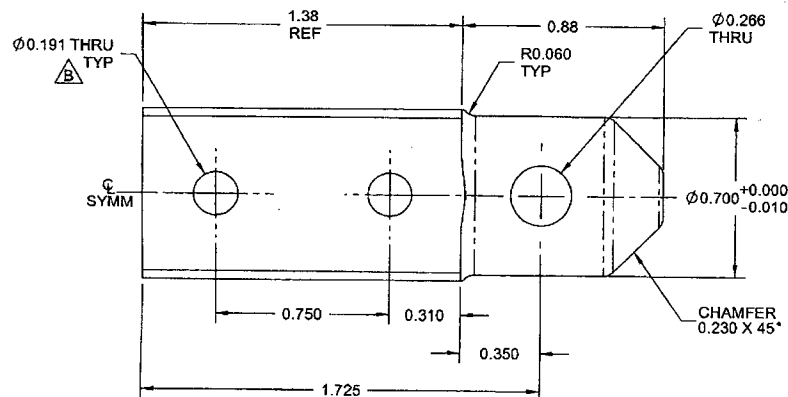
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4148-5 EYEBOLT STUD

Wb 61006

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2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

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